

slip Jan 5

Dart Aerospace Ltd.

Date: Wednesday, 12/20/2006 11:59:01 AM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BUSHING
<b>Job Number</b> : 29991	
<b>Estimate Number</b> : 10308	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D26173
<b>This Issue</b> : 12/20/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2617 REV D2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D2
<b>Previous Run</b> : 27738	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 12/29/2006
<b>Checked &amp; Approved By</b> : <u>[Signature]</u> 06/12/20	<b>Qty</b> : 280 <b>Um</b> : Each
<b>Comment</b> : Est G 04.07.14 Reformat; added step 5KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W
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**Comment:** Qty.: 0.0765 f(s)/Unit Total : 3.0618 f(s)  
6061-T6 Round Bar 1.5"  
Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)  
Ø0.375" tubing x 0.058" wall  
(M6061T6T0.375W.058) Batch: M19051

sf 06/12/23

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE  
Turn as per Folio FA437 and Dwg D2617

DP 06/12/24 sf 06/12/23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

sf 06/12/23

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

sf 06/12/23

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Deburr break all unmarked sharp edges 0.005 to 0.010

sf 06/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/02

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 11:59:02 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29991

Part Number: D26173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

*mm / 401/9 m*

*06/12/28*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*mm 06 12 28*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 53*

*LB07/01/02*

*(579)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*LB07/01/02*

*(279)*

Job Completion



*CL07101102*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

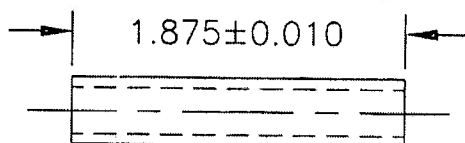
**NOTE:** Date & initial all entries



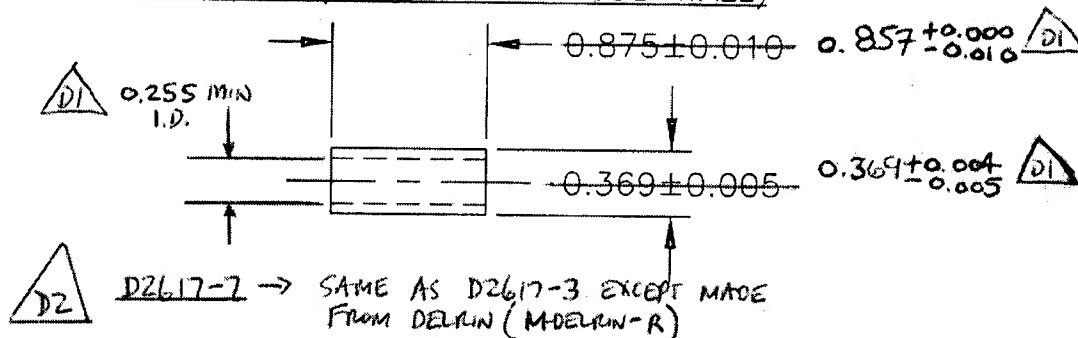


DESIGN BW		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING	SCALE 1:1
A	96.10.08		NEW ISSUE		
B	97.05.08		.875 WAS 1.125		
C	97.06.04		0.369 DIA WAS 0.375		
D	01.07.04		ADD MAT'L SPEC AND TOL./DIM. NOTE		
DI	CP-#	04.07.12	CORRECT TOLERANCE (NCR 779)		

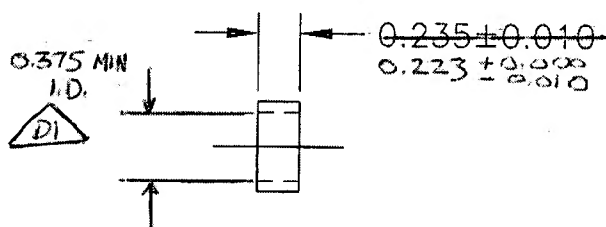
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05 #

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29991

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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